



Dart Aerospace Ltd.
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Canada

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D2010-104
Job Sheet 182346



Part No: D2010-104

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP A 04.02.17 New issue KJ/JLM IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Small Fab-4		SMB
100	Brake NC	4 pcs	9/7/18	9/7/18	0.00	1.30	Brake NC 3		SMB
110	Small Fab	4 pcs	9/7/18	9/7/18	0.00	1.00	Small Fab-1		SMB
120	Small Fab	4 pcs	9/7/18	9/7/18	0.00	0.82	Small Fab-1	N/A	DAS
130	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC5		AUG 29 2018 68
140	Powdercoat	4 pcs	9/7/18	9/7/18	0.00	0.12	Powdercoat4		SEP 07 2018 68
150	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC3		SEP 07 2018 68
160	Packaging	4 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1	5735198	SEP 07 2018 68
170	QC21-SA	4 Ea	9/7/18	9/7/18	0.00	0.00	QC21		SEP 11 2018 68

Part Op 100 - Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104

Descriptions: 110 - 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- flare before installing plug as per dwg D2010 3- Install D2057 plug as per Dwg D2010

120 - 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010

140 - START TIME: 9:25 OVEN TEMPERATURE: 350° FINISH 10:25.

M138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	6 ft (1.5 ea)	90-Start up Operation	509269
D2057	Plug	4 Ea (1 ea)	110-Small Fab	507985

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.049	6	180	0
110-Small Fab	D2057 CA26	4	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	7.900inches ± 0.030	7.930 7.870		
2	Arm	10.200 ± 0.030			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

3	Arm	45.000Degree $\pm$ 0.500	45.500 44.500
4	Arm	45.000Degrees $\pm$ 0.500	45.500 44.500
5	Arm	0.600inches + 0.008 - 0.001	0.608 0.599

Plex 8/23/18 7:58 AM Dart.lajeunesse.marie

DAK
AEROSPACE

Container No: S106474

Part: D2010-104

Job No: 182346

Serial No/Batch: S106474

Revision:

Inspection:

Exp Date:

Instructions: Various STC's

Date: 08/29/18

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Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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